

Date: Friday, 09/05/2008 1:51:58 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: DOOR ASSEMBLY		
Job Number	: 39169C			Part Number	: D41269403		
Estimate Number	: 12353			Drawing Number	: D412-694		
P.O. Number	:			Project Number	: N/A		
This Issue	: 09/05/2008 S.O. No. :			Drawing Revision	: C1		
Prsh Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 15/06/2008 Qty: 1 Um: Each		
Previous Run	: 36652C						
Written By	:						
Checked & Approved By	<u>JLD</u> 08.5.09						
Comment	: Est Rev: A 05.12.09 New Issue KJ/RF						
	Est Rev: B 06.04.18 New dwg rev. ecn781 EC						
	Est Rev: C 06.07.11 Revised per B24660 KJ						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL 
		Comment: DOCUMENT CONTROL <u>JLD 08-7.18</u> Issue red decal labels for D412-694-03. CHG005
2.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY 
		Comment: COMPOSITE ASSEMBLY D412-694-03 Drill Process 1- Drill pilot holes Ø(#30) using drill Jig D3144-T4 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T5/-T6 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference. <u>080618</u> 2- Drill Pilot holes Ø(#30) using drill Jig D3120-3T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3. <u>080617</u> 3- Drill Pilot holes Ø(#30) using drill Jig DT8703-4 for hinges, top cover and D3131-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM). <u>080617</u> 4- Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-5. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF.). <u>080617</u> 5- Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-6. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF.). <u>080617</u> 6- Ensure 17 1/16" from opposite edge of the door for Ø5/8" hole is in proper location top and bottom. <u>080617</u> 7- Drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA). <u>080617</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 39169C		Part Number: D41269403
Job Number:		
Seq. #:	Machine Or Operation:	Description :
3.0	8000528	Insert
Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s) Insert M19443		21 080617
Batch		
A/R Hysol EA934NA		M107007
Expiry Date: 090131		080618
4.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
Comment: COMPOSITE ASSEMBLY		
1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM). 2- Sand flush excess Hysol around the insert on both doors.		080619
5.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		080626 ①
Inspect that inserts are flush with the surface.		
6.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
Comment: COMPOSITE ASSEMBLY		
1. Apply Primer filler and reducer around the inserts on both doors. A/R 11045 Primer Filler Batch: 108307 A/R 12375S Reducer Batch: 105936		080626 ①
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		080626 ① PTO
8.0	D31101	Escutcheon
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Escutcheon Batch 31757		0805/13 XI
9.0	D31103	Handle
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Handle Batch 36724		0805/13 XII

W/O: 39169C		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-07-21	7.0	QC 14 required. Est # 12353 perm. change				108-07-21	108-07-21

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Seq. #:	Machine Or Operation:	Description :	
10.0	D3111041	Plate Assembly	<i>KS 08/05/13 (x)</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Plate Assembly Batch <u>M10536-17</u>	
11.0	D311121	Guide	<i>KS 08/05/13 (x)</i>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Guide Batch <u>35122</u>	
12.0	D311131	Spring	<i>KS 08/05/13 (x)</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Spring Batch <u>B36728</u>	
13.0	D311141	Pivot	<i>KS 08/05/13 (x)</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pivot Batch <u>B36726</u>	
14.0	D311165	Seal	<i>KS 08/05/13 (x)</i>
		Comment: Qty.: 5.6700 f(s)/Unit Total : 5.6700 f(s) Seal 110-031-4 Batch <u>B23099</u>	
15.0	D3111611	Seal	<i>KS 08/05/13 (x)</i>
		Comment: Qty.: 1.5000 f(s)/Unit Total : 1.5000 f(s) SEAL Batch <u>B24697</u>	
16.0	D31119041	Cover Assembly	<i>KS 08/05/13 (x)</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Cover Assembly Batch <u>27724</u>	

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 D31201 Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover, Flat Pattern

Batch

10563-17

AS 08/05/13 (X)

18.0 D31203 Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

B18658A

AS 08/05/13 (X)

19.0 D31251 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

D3125-1 Lever

Batch

M10536-17

AS 08/05/13 (X)

20.0 D31253 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

M10536-17

AS 08/05/13 (X)

21.0 D31255 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

M10536-17

AS 08/05/13 (X)

22.0 D31257 Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

M10536-17

AS 08/05/13 (X)

23.0 D31291 Lever



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lever

Batch

M10536-17

AS 08/05/13 (X)

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Seq. #:	Machine Or Operation:	Description :
24.0	D31301	Clevis Base 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Clevis Base Batch M10536-17  AS 08/05/13 (X)
25.0	D31311	Stop 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Stop Batch M10536-17  AS 08/05/13 (X)
26.0	D31341	Rod 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rod Batch 27338  AS 08/05/13 (X)
27.0	D31343	Rod 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) D3125-3 Rod Batch 18376  AS 08/05/13 (X)
28.0	D314007	Door 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Door Kit Batch M10536-17 39169D  AS 08/02/20 (X)
29.0	D31431	Clevis 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Clevis Batch M10536-17  AS 08/05/13 (X)
30.0	D31433	Clevis 
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Clevis Batch M10536-17  AS 08/05/13 (X)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:	Machine Or Operation:	Description :
31.0	D31441	Doubler 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) 143 Doubler Batch 18816
32.0	D3144105	Doubler 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) 143 Doubler Batch 23143
33.0	D3144107	Doubler 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) 143 Doubler Batch 23144
34.0	D31451	Bracket 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) 69 Bracket Batch 326582
35.0	D31461	Bracket 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) 69 Hinge Bracket Batch 326909
36.0	D31471	Pin 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) 69 Pin Batch 30824
37.0	D31491	Striker Plate 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) 69 Striker Plate Batch M10536-12

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Job Number:



Seq. #: Machine Or Operation:

Description :

38.0 D31501 Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

F2

Guide  
Batch

M10536-17

AS 08/05/13 (x1)

39.0 D31541 Key



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

F2

Key  
Batch

M10536-17

AS 08/05/13 (x1)

40.0 D31571 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

F3

Spacer  
Batch

M10536-17

AS 08/05/13 (x1)

41.0 D3159041 Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

F3

Bracket Assembly  
Batch

186041

AS 08/05/13 (x1)

42.0 D3159043 Bracket Assembly



PTO

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

F3

Bracket Assembly  
Batch

24859

AS 08/05/13 (x1)

43.0 AN52510R7 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

F3

Screw  
Batch

M160166

AS 08/05/13 (x1)

44.0 AN960JD6L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

F3

Washer  
Batch

5519

AS 08/05/13 (x1)

W/O: ~~39~~ 39169C

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
080716	42.	Replace 3159-043/044 WITH D3159-041 Remove Step 9 of Seq# 77.0 IAW E-mail from R.F	<i>[Signature]</i>	080716	1		

Part No: D412-693-03 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #: Machine Or Operation:

Description :

45.0 AN960JD8 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

M107091

AS 08/05/13 (X)

46.0 AN960JD8L Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

M10956

AS 08/05/13 (X)

47.0 AN960JD10 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

M107715

AS 08/05/13 (X)

48.0 AN960JD10L Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

M104885

AS 08/05/13 (X)

49.0 AN960JD10LL Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Washer

M19600

AS 08/05/13 (X)

50.0 ALS463280 Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Insert

M17841

AS 08/05/13 (X)

51.0 BSP45 Commercial Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Commercial Rivet

M107296

AS 08/05/13 (X)

W/O:		WORK ORDER CHANGES					
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Seq. #: Machine Or Operation:

Description :

52.0 BSP46 Commercial rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Commercial rivet

Batch

M161237

AS 08/05/13 (x)

53.0 FW4032 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M161203

AS 08/05/13 (x)

54.0 FW10032 Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

M19249

AS 08/05/13 (x)

55.0 M7885344 Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivets

Batch

M19099

AS 08/05/13 (x)

56.0 M7885345 Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rivet

Batch

1108

AS 08/05/13 (x)

57.0 MS203921C11 Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M18822

AS 08/05/13 (x)

58.0 MS203922C11 Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M14149

AS 08/05/13 (x)

Dart Aerospace Ltd

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59.0	MS203922C15	Pin
	Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)	
	Pin	
	Batch	M101340
		08/05/13 (X1)
60.0	MS21042L3	Nut
	Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)	
	Nut	
	Batch	M107644
		08/05/13 (X1)
61.0	MS21042L06	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Nut	
	Batch	M107898
		08/05/13 (X1)
62.0	MS24665151	Cotter Pin
	Comment: Qty.: 11.0000 Each(s)/Unit Total : 11.0000 Each(s)	
	Cotter Pin	
	Batch	M14526
		08/05/13 (X1)
63.0	MS24694C4	SCREW
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	SCREW	
	Batch	M15924
		08/05/13 (X1)
64.0	MS24694S53	SCREW
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	SCREW	
	Batch	M15798
		08/05/13 (X1)
65.0	MS24694S56	SCREW
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	SCREW	
	Batch	M104407
		08/05/07 (X1)

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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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66.0	MS24694S60	Screw	AS 08/05/13 (x)
			<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Screw Batch M104407</p>
67.0	MS25281R6	Clamp	AS 08/05/13 (x)
			<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Clamp Batch M19098</p>
68.0	MS27039106	Screw	AS 08/05/13 (x)
			<p>Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s) Screw Batch M106815</p>
69.0	MS27039108	Screw	AS 08/05/13 (x)
			<p>Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Screw Batch M106589</p>
70.0	MS35206231	Screw	AS 08/05/13 (x)
			<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Screw Batch M11735</p>
71.0	MS35650305T	Nut	AS 08/05/13 (x)
			<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Nut Batch M11786</p>
72.0	MS518597	Washer	AS 08/05/13 (x)
			<p>Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Washer Batch M106421</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:51:59 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:	Machine Or Operation:	Description :	
73.0	NAS116910L	Washer	<i>AS 08/05/13 (x)</i>
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Washer Batch <u>M11753</u>	
74.0	NAS38868P	Screw	<i>AS 08/05/13 (x)</i>
		Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s) Screw Batch <u>M19098</u>	
75.0	NAS391B6P	Washer	<i>AS 08/05/13 (x)</i>
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) Washer Batch <u>M19098</u>	
76.0	NAS43DD340	Spacer	<i>AS 08/05/13 (x)</i>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Spacer Batch <u>M11737</u>	
77.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY	<i>AS 08/05/13 (x)</i>
		Comment: COMPOSITE ASSEMBLY D412-694-03 Assembly Process 1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF). <i>AS 080709</i>	
		2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB). Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door. <i>AS 080710</i>	
		3- Assemble Rod as per Dwg D412-694 page 5 (view W) <i>AS 080710</i>	
		4- Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF). <i>AS 080710</i>	
		5- Connect Rods and D3111-041 Plate Assembly as per Dwg D412-694 page 5 (view W). <i>AS 080710</i>	
		6- Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x <i>AS 080710</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:51:59 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:	Machine Or Operation:	Description :
	100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg D412-694 page 5 (view W).	
	7- Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket. Drill Ø#30 C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) <i>A 080715</i>	
	8- Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps. <i>A 080715</i>	
	9- Install (1) D3159-043 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler. Note: Layout properly as per Dwg D412-694 page 5 (view W). Note: Second hole will be done with doubler and seal. <i>N/A</i>	
	10- Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together. Note: Position strike plate when big door is in locked position. <i>A 080715</i>	
	11- Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3. <i>A 080716</i>	
	12- Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ) <i>A 080716</i>	
	13- Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC). <i>A 080716</i>	
	14- Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM). <i>A 080716</i>	
	15- Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3. A/R RTV732 Clear Batch: <u>1108687</u> Expiry Date: <u>090717</u> <i>A 080718</i>	

FOR D412-694-011 ONLY

16- Drill Pilot holes Ø#1/8" for D3119-041 cover using drilling Jig D3119-041T1/T2 as per Dwg D412-694 page 3. Trim D3119-041 Cover Assembly and transfer Ø#30 holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156). *A 080716*

78.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:51:59 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:	Machine Or Operation:	Description :
79.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment:	SMALL & MEDIUM FAB RESOURCE 1 (Put red label inside before putting the cover D3119-041 or Vip trim)	080718
1-	Install D3119-041 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.	
80.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment:	INSPECT WORK TO CURRENT STEP	080724(D)
81.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment:	PACKAGING RESOURCE #1 Identify and Stock Location: _____	888 39169A11 u 08.08.25
82.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment:	FINAL INSPECTION/W/O RELEASE	08/08/25  08.08.25

Job Completion



u 08.08.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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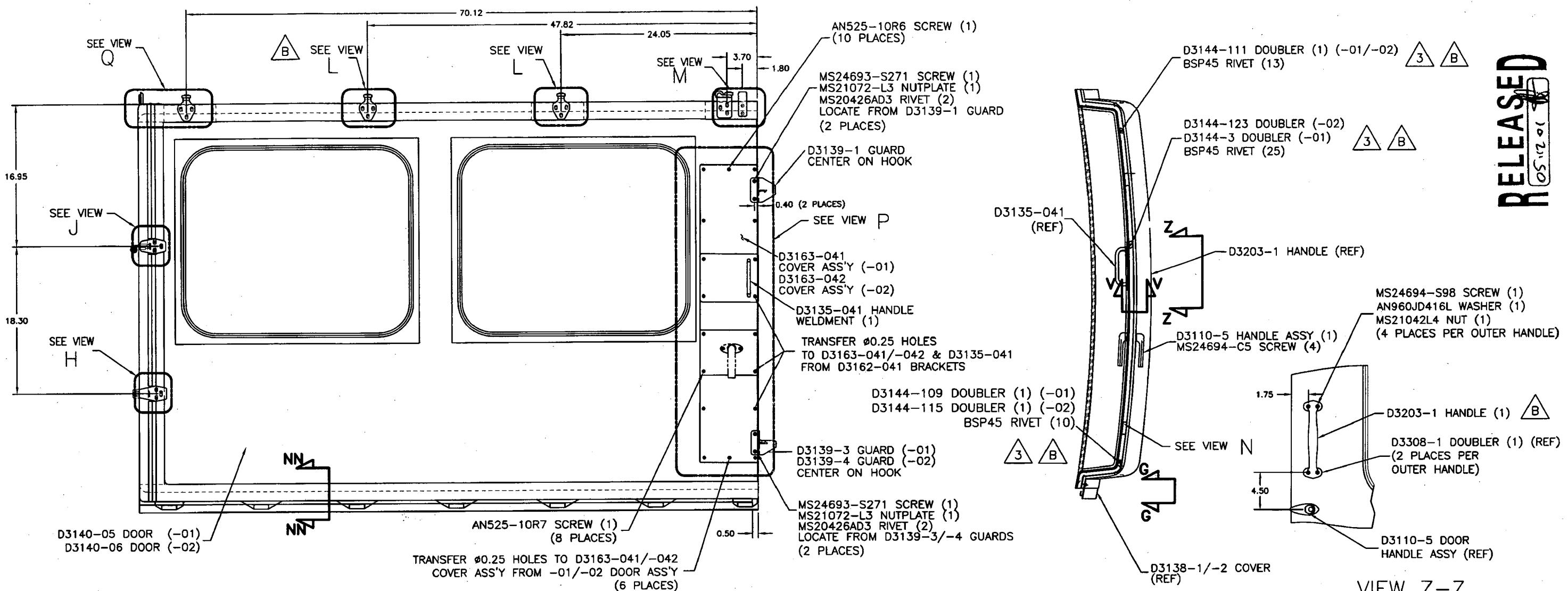
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NO. 39/62

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-694-01	DOOR ASSEMBLY
	X			D412-694-02	DOOR ASSEMBLY
	X			D412-694-03	DOOR ASSEMBLY
		X		D412-694-04	DOOR ASSEMBLY
			1	D3110-1	ESCUTCHEON
		1	1	D3110-3	HANDLE
1	1			D3110-5	HANDLE ASSEMBLY
		1	1	D3111-041	PLATE ASSEMBLY
		2	2	D312-21	GUIDE
		1	1	D3113-1	SPRING
		1	1	D3114-1	PIVOT
1	1			D3115-1	BRACKET
		1	1	D3116-11-0180	SEAL
		1	1	D3116-5-0680	SEAL
1	1			D3116-7-0680	SEAL
1	1			D3116-9-0770	SEAL
		1		D3119-041	COVER ASSEMBLY
		1		D3119-042	COVER ASSEMBLY
		1		D3120-1	COVER
		1		D3120-2	COVER
		1		D3120-3	COVER
		1		D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY ("ROLLER")
1				D3121-043	BRACKET ASSEMBLY ("ROLLER")
	1			D3121-044	BRACKET ASSEMBLY ("ROLLER")
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOOK
1	1			D3124-2	HOOK
		1	1	D3125-1	LEVER
		1	1	D3125-3	LEVER
		1	1	D3125-5	LEVER
		1	1	D3125-7	LEVER
1	1			D3126-1	BRACKET ("SLIDER")
1	1			D3126-3	BRACKET ("SLIDER")
5	5			D3126-5	BRACKET ("SLIDER")
1	1			D3127-1	SPACER
		1	1	D3128-1	SHIM
		2	2	D3129-1	LEVER
		2	2	D3130-1	CLEVIS BASE
		1	1	D3131-1	STOP
1				D3132-041	ROD WELDMENT
1				D3132-042	ROD WELDMENT
1				D3133-041	ROD WELDMENT
1				D3133-042	ROD WELDMENT
		1	1	D3134-1	ROD
		1	1	D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
1				D3138-1	COVER
1				D3138-2	COVER
1				D3139-1	GUARD
1				D3139-3	GUARD
1				D3139-4	GUARD
1				D3140-05	DOOR
1				D3140-06	DOOR
		1		D3140-07	DOOR
		1		D3140-08	DOOR
2	2			D3141-1	SPRING
		1	1	D3143-1	CLEVIS
		3	3	D3143-3	CLEVIS
		1		D3144-1	DOUBLER
1				D3144-3	DOUBLER
		1		D3144-105	DOUBLER
		1		D3144-107	DOUBLER
1				D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
		1		D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		1		D3146-1	HINGE BRACKET
		1		D3146-2	HINGE BRACKET
2	2			D3147-1	PIN
		2	2	D3148-1	CLEMS
		2	2	D3149-1	STRIKER PLATE
		2	2	D3150-1	GUIDE
		1	1	D3151-041	DOUBLER ASSEMBLY
		1		D3152-041	BRACKET ASSEMBLY
		1		D3152-042	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
		1	1	D3155-041	BRACKET ASSEMBLY
		1	1	D3155-042	BRACKET ASSEMBLY
2	2			D3156-1	BRACKET
		2	2	D3157-1	SPACER
		3	3	D3159-041	BRACKET ASSEMBLY
		1		D3159-043	BRACKET ASSEMBLY
		1		D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1	1			D3162-043	BRACKET ASSEMBLY
1			1	D3162-044	BRACKET ASSEMBLY
		1		D3163-041	COVER ASSEMBLY
		1		D3163-042	COVER ASSEMBLY
		1		D3183-041	BRACKET ASSEMBLY ("ROLLER")
		1		D3183-042	BRACKET ASSEMBLY ("ROLLER")
		1	1	D3203-1	HANDLE ASSEMBLY
		2	2	D3308-1	DOUBLER
55	55	21	21	80-005-28	INSERT (OR SL2052-3-4)
10	10			AN625-10R6	SCREW
8	8	4	4	AN625-10R7	SCREW
	8	8		AN600JD10	WASHER
18	18	4	4	AN600JD10L	WASHER
13	13	32	32	AN600JD10LL	WASHER
6	6			AN600JD16L	WASHER
		4	4	AN600JD6L	WASHER
6	6			AN600JD8	WASHER
		2	2	AN600JD8L	WASHER
		2	2	AN600JD8LL	WASHER
		10	10	ASL4-632-80	INSERT
87	87	50	50	BSP45	RIVET
		12	12	FWD0-032	WASHER
		6	6	FWD-032	WASHER
12	12			M7885-2-4	RIVET (OR CR3213-4)
		3	3	M7885-2-4	RIVET (OR CR3212-4)
		2	2	MS20392-1C11	PIN
		7	7	MS20392-2C15	PIN
2	2			MS20392-2C17	PIN
2	2	2	2	MS20392-2C9	PIN
2	2			MS20392-3C21	PIN
8	8			MS20426AD8	RIVET
12	12			M7885-3-4	RIVET
8	3			MS20426AD4	RIVET

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
-20	-20			MS20426AD4	RIVET
	6	6	2	MS21042L05	NUT
6	6	2	2	MS21042L08	NUT
	5	5	5	MS21042L3	NUT
4	4			MS21072-14	NUT
4	4			MS21072-13	NUTPLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24693-S271	SCREW
4	4			MS24694-C4	SCREW
6	6			MS24694-C5	SCREW
18	18			MS24694-S55	SCREW
	4	4		MS24694-S56	SCREW
	2	2		MS24694-S53	SCREW
	4	4		MS24694-S80	SCREW
4	4			MS24694-S98	SCREW
2	2	2	2	MS25281-P6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-06	SCREW
13	13	6	6	MS27039-1-08	SCREW
	2	2		MS32020-231	SCREW
2	2			MS32725-233	SCREW
	4	4		MS36649-264	NUT
2	2			MS36	

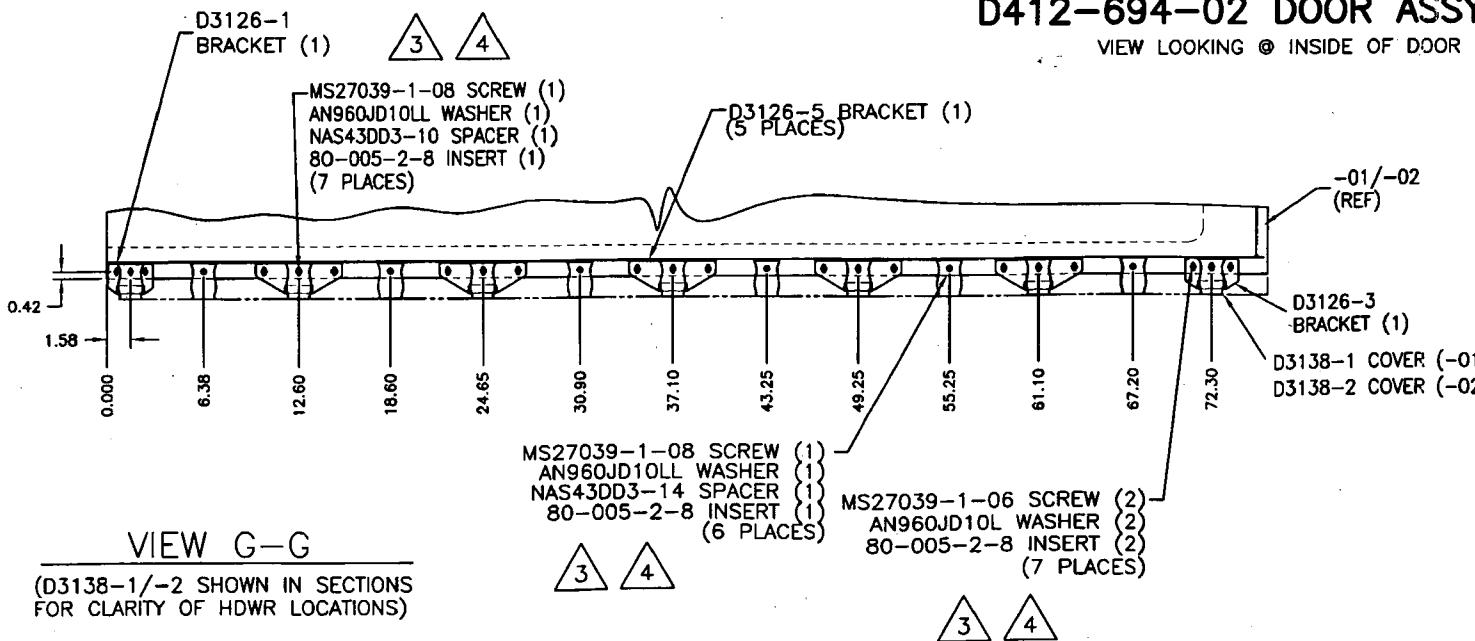
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### D412-694-01 DOOR ASSY (SHOWN)

### D412-694-02 DOOR ASSY (OPP.)

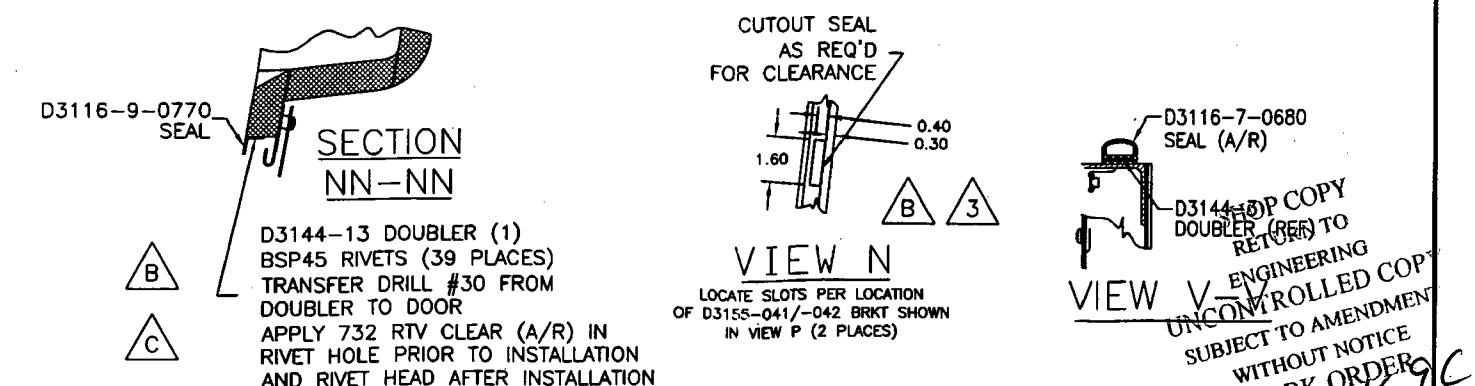
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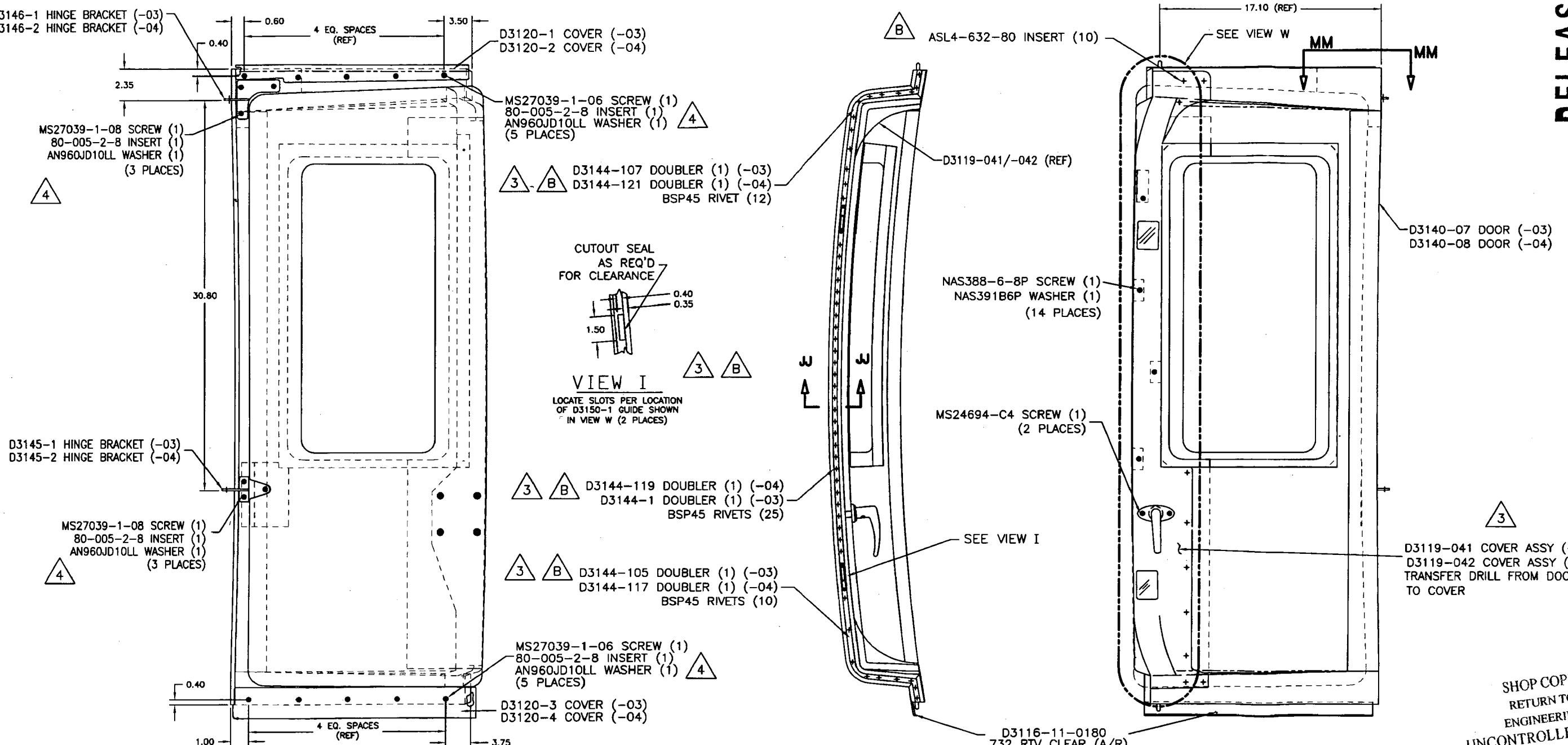
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DATE 05.11.23	TITLE DOOR ASSEMBLY	SCALE	NTS



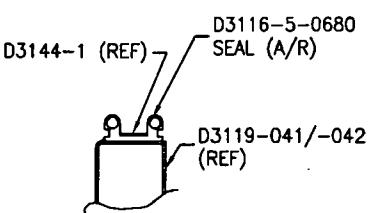
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**D412-694-03 DOOR ASSY (SHOWN)**  
**D412-694-04 DOOR ASSY (OPP)**



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HAWKESBURY, ONTARIO, CANADA

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D412-694

DATE

05.11.23

TITLE

DOOR ASSEMBLY

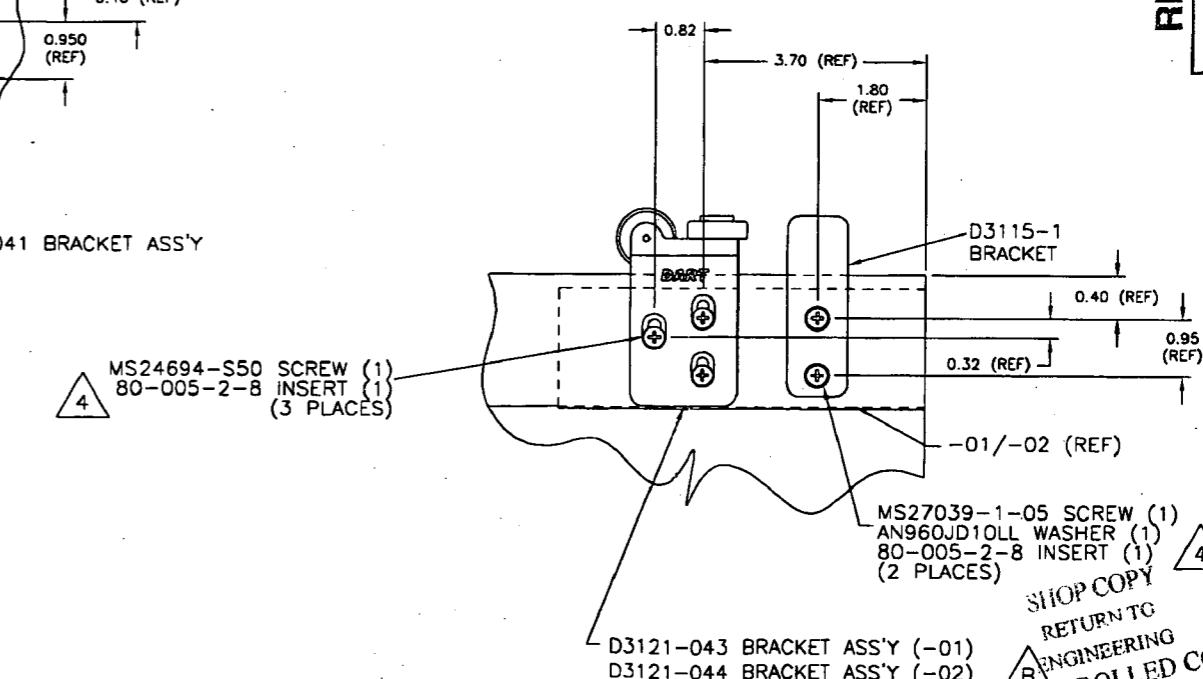
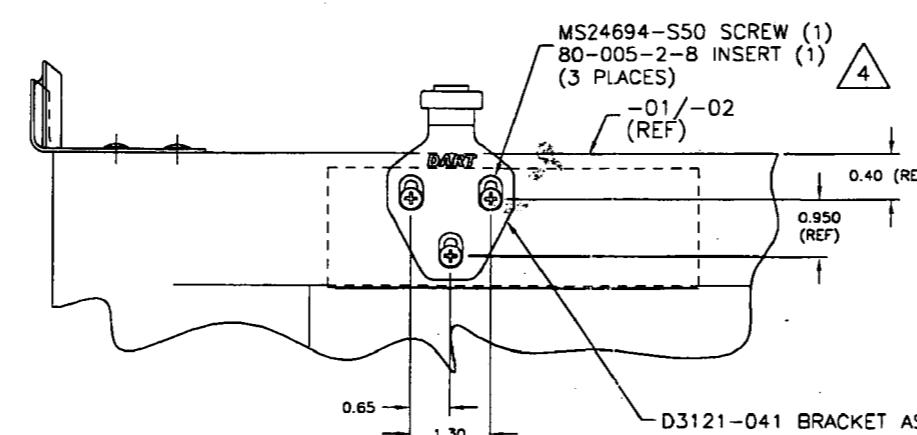
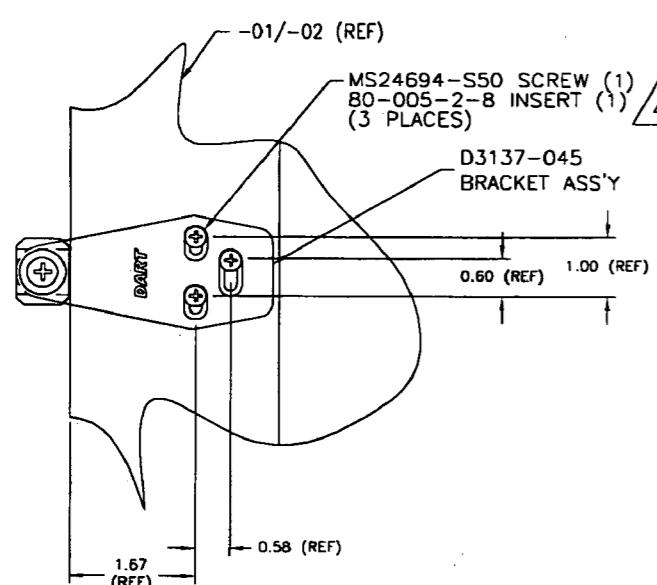
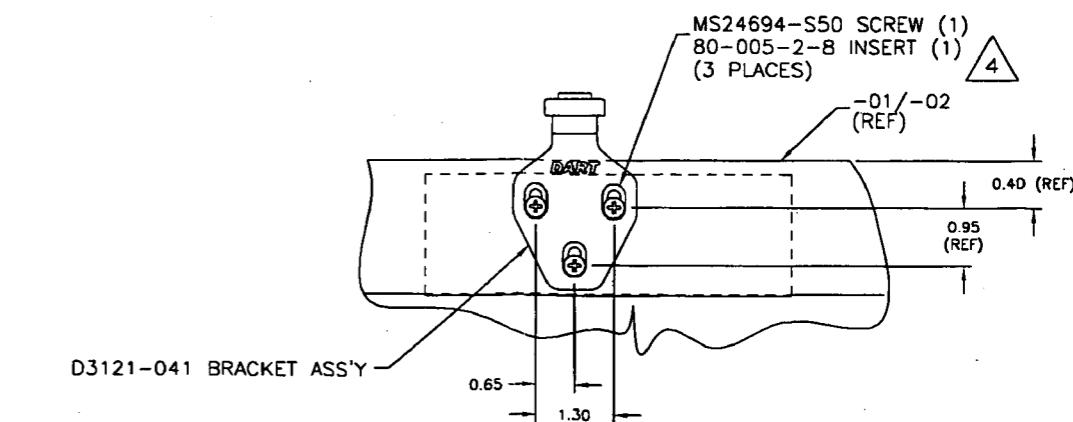
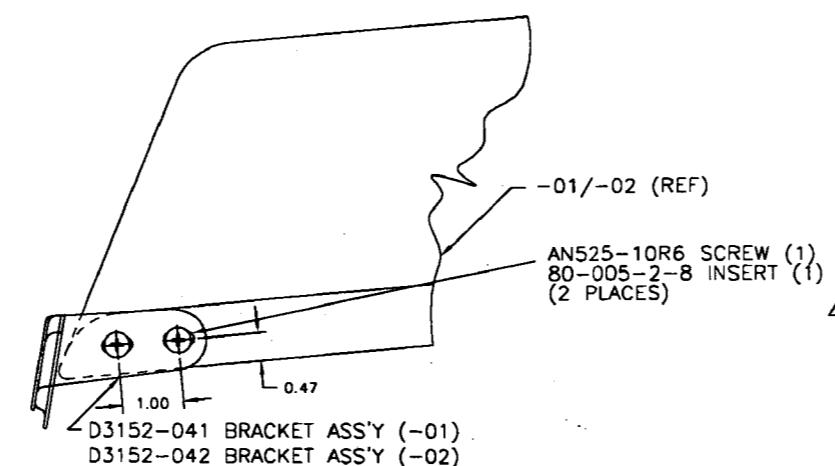
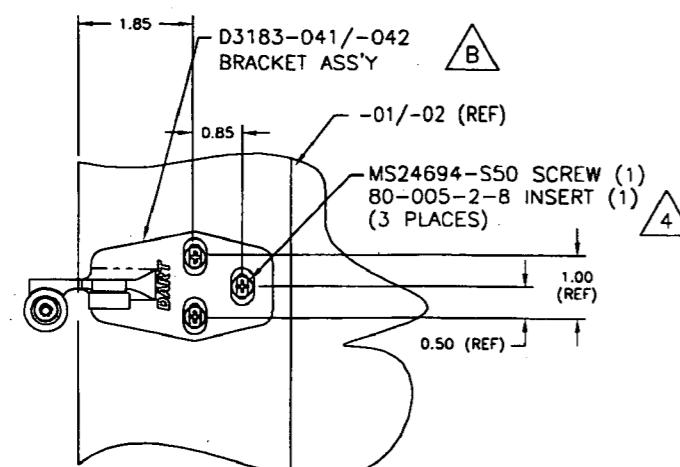
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SHEET 3 OF 6

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CHECKED	APPROVED	#	#	DRAWING NO.	D412-694	REV. C	SHEET 6 OF 6
DATE	05.11.23	TITLE	DOOR ASSEMBLY	SCALE	NTS		

**Dan Stow**

---

**From:** Mike Petsche [mpetsche@dartaero.com]  
**Sent:** July 16, 2008 11:32 AM  
**To:** 'Dan Stow'; 'Roberto Fuentes'  
**Subject:** RE: spacedoor nuplates

uuuh...ok....

Yes.

---

**From:** Dan Stow [mailto:[dstow@dartaero.com](mailto:dstow@dartaero.com)]  
**Sent:** July 16, 2008 11:35 AM  
**To:** 'Roberto Fuentes'  
**Cc:** 'Mike Petsche'  
**Subject:** RE: spacedoor nuplates

Mike – just say yes and all will be good.

**Dan Stow**  
**Technical Support**  
**Dart Aerospace**  
**Tel: 613.632.5200**  
**Cell: 613.676.0992**  
**[dstow@dartaero.com](mailto:dstow@dartaero.com)**

---

**From:** Roberto Fuentes [mailto:[rfontes@dartaero.com](mailto:rfontes@dartaero.com)]  
**Sent:** July 16, 2008 11:30 AM  
**To:** 'Dan Stow'  
**Cc:** Mike Petsche  
**Subject:** RE: spacedoor nuplates

If Mike is ok with the replacement of this bracket I am ok too, because will create of alter IIN/ICA. Make sure D3159-041 bracket doesn't interfere with function of D3149-1 striker plate.

Roberto

---

**From:** Dan Stow [mailto:[dstow@dartaero.com](mailto:dstow@dartaero.com)]  
**Sent:** Wednesday, July 16, 2008 8:44 AM  
**To:** 'Roberto Fuentes'  
**Subject:** FW: spacedoor nuplates

1965.0.1.004

For the first time in 1965, we had a  
good crop of *Leucospermum cordatum*.  
The plants were very tall, up to 1.5 m.  
and the flowers were large and showy.

1965.0.1.005  
A small plant, about 1 m. tall,  
with many flowers. The flowers  
are yellow and showy.

1965.0.1.006  
A small plant, about 1 m. tall,  
with many flowers. The flowers  
are yellow and showy.

1965.0.1.007  
A small plant, about 1 m. tall,  
with many flowers. The flowers  
are yellow and showy.

Hi Roberto,

Please send an email to confirm that Russ can replace the D3159-043/-044 brackets with D3159-041 bracket.

**Dan Stow**  
**Technical Support**  
**Dart Aerospace**  
**Tel: 613.632.5200**  
**Cell: 613.676.0992**  
**[dstow@dartaero.com](mailto:dstow@dartaero.com)**

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**From:** Dan Stow [mailto:[dstow@dartaero.com](mailto:dstow@dartaero.com)]  
**Sent:** July 15, 2008 5:17 PM  
**To:** 'Roberto Fuentes'  
**Subject:** spacedoor nuplates

Hi Roberto,

If you look at pic 004 you will see where the nutplate is currently located. We measured from the slot to the nutplate (10" – 4") at 6 inches. At this location the screw will enter the plastic at such an angle that the head of the screw will be touching on one side and not the other.

Pic 003 is one proposal we have which would move the nutplate down past the curve on the plastic. Location is 2 inches from the slot.

Pic 006 is the proposal we think is best for two reasons. First reason is that we are only moving the nutplate by 3.25" and it will still be out of the curve on the plastic. Second reason is that with the D3159-043/044 brackets the installer must install one rivet before installing the outside doubler and than one after. With the D3159-041 brackets both rivets can be installed at the same time, thus eliminating the need to manufacture the D3159-043/ 044 brackets.

**Dan Stow**  
**Technical Support**  
**Dart Aerospace**



DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice #	12639
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

### Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

### Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via	F.O.B.		Terms	Salesperson	
EPIC EXPRESS COLLECT		Point de départ		Net30 days	Claude Lessard, ext. 233
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #
28/04/2008	08/06/2006	4699	C. Lavoie	PO00001429	
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description	
1	0	1	DKC135-0019	D3140-06 Door Right Non Assy ( Grosse ) Job: 42212	
1	0	1	DKC135-0020	D3140-08 Door Right Non Assy ( Petite ) Job: 42212	
1	0	1	DKC135-0017	D3140-05 Door Left Non Assy ( Grosse ) Job: 42210	
1	0	1	DKC135-0018	D3140-07 Door Left Non Assy ( Petite ) Job: 42210	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Cust.

Adm.

Quality

Ship.

Accepted by:

Quality department

AQ-357



Date: Lundi, 2007-11-12 10:54:08  
 Utilisateur: Marc Dubé

## Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : DOOR
Numéro Job : 42212		Numéro Article : DKC135-0010/-0014
Numéro Soumission : 1726		Numéro Dessin : D3140
Numéro B.A. :		Projet Numéro : DKC135
Cette fois : 2007-11-12	No. B.V. :	Révision dessin : F
Prsht Rev. : NC		Matériel : Tissu Fibercore E-761/7788
Prem. fois : -	Type :	Date Dûe : 2007-10-11
Job précédente : 42211		Qté: 1
UdM: UNITE		
Écrit par :		
Vérifié & Approuvé par :		
Commentaires :	N° de pièce Dart Aerospace: D3140-06/-08 N° de pièce Delastek Aeronautique: DKA359-0010/-0011 N° de pièce Delastek Composites: DKC135-0010/-0011	
Process Sheet Rév.: 11 Changer la révision de dessin pour la Rév.: F		

### Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	OUTILLAGE	OUTILLAGE NÉCESSAIRE À LA FABRICATION

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
 OUTILLAGES NÉCESSAIRES À LA FABRICATION DE LA PIÈCE

Moule N° B30-23000-02T  
 Patron de découpe N° B30-23000-57T  
 Patron de découpe N° B30-23000-61T  
 Patron de découpe N° B30-23000-63T  
 Patron de découpe N° B30-23000-69T  
 Patron de découpe N° B30-23000-71T  
 Patron de découpe N° B30-23000-73T  
 Patron de découpe N° B30-23000-75T  
 Patron de découpe N° B30-23000-77T  
 Patron de découpe N° B30-23000-79T  
 Gabarit de taillage N° B30-23000-06T ( 2 pièce ) et N° B30-2300-04T  
 Forme de silicone N° B30-23000-08T

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
 PRÉPARATION DU MOULE

Préparation du moule selon la section 5.0 de l'instruction de travail TEC-77

Quantité: 1 Date: 23-11-07 Sceau: 

Date: Lundi, 2007-11-12 10:54:08  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART	Dart Aerospace Ltd.	Nom Dessin: DOOR
Numéro Job: 42212		Numéro Article: DKC135-0010/-0011
Numéro Job:		
# Séq.:	Machine ou Opération:	Description :
3.0	AMB0211	PREPERG FIBERCOTE E761/7781 roul. 50"
Commentair Qty.: 12.3 VERGE(s)/Unit Total : 12.3 VERGE(s)		
PREPERG FIBERCOTE E761/7781 roul. 50"		
N° de Lot: 1-6293-1		
4.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs		
DÉCOUPAGE MATÉRIEL		
Découpe du tissu pré-imprégné e-761 paquets de 10.5 pi <sup>2</sup> . ( 7 paquets =24.5 Verges )		
Quantité: 1 Date: 16/11/07 Sceau:		
5.0	DRAPAGE 1	DRAPAGE DART
Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs		
DRAPAGE DES PIECES		
Faire le drapage de 3 plis de tissu pré-imprégné e-761 ( 4 Paquets ) selon la section 8.1.1 de l'instruction de travail N° TEC-77.		
Quantité: 1 Date: 26/11/07 Sceau:		
6.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)		
Tissu à délaminer Release ply B		
7.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)		
Wrightlon 5200 Bleu P3		
8.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)		
Feutre de drainage N° Airweave N 10		
9.0	AC0755	Sac à vide N° Strehlon 700
Commentair Qty.: 7.770 METRE CAR(s)/Unit Total : 7.770 METRE CAR(s)		
Sac à vide N° Strehlon 700		
10.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
Commentair Qty.: 2.0000 RL(s)/Unit Total : 2.0000 RL(s)		
Ruban à gommer jaune #: T/AT-200Y		

Date: Lundi, 2007-11-12 10:54:08  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42212

Nom Dessin: DOOR  
Numéro Article: DKC135-0010-0011

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
11.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE

Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.1 de l'instruction de travail N° TEC-77.

Quantité: /

Date: 26/11/07 Sceau:



12.0 CUISSON 1

CUISSON PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

CUISSON DES PIECES

Faire la cuisson selon la section 8.3.1 de l'instruction de travail N° TEC-77

Inscrire le N° de cuisson: 5741

Quantité: /

Date: 26/11/07 Sceau:



13.0 DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

DÉMOULAGE DES PIECES

Retirez le montage cuisson et faire les retouches de la pièce, afin d'enlever les surplus de résines et les résidus de tissu à délaminer.

Quantité: /

Date: 27/11/07 Sceau:



14.0 INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

INSPECTION GÉNÉRALE

Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: /

Date: 27/11/07 Sceau:



Date: Lundi, 2007-11-12 10:54:09  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART	Dart Aerospace Ltd.	Nom Dessin: DOOR
Numéro Job: 42212		Numéro Article: DKC135-0010-0011
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
15.0	ACP006	Rohacell 71S 1"thick 49.2" x 98.4" plain
Commentair Qty.: 2.00 UNITE(s)/Unit Total : 2.00 UNITE(s) Rohacell 71S 1"thick 49.2" x 98.4" plain		
N° de Lot: <u>1-6290-1</u> <u>1-5733-1</u>		
16.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
		
Commentair Setup: 0.00Hrs/ Run: 360.0000Min Total Run : 6.0000Hrs DÉCOUPAGE PRIMAIRE		
Faire la découpe des pièces de mousse structurales ( Rohacell ) sur la scie à ruban selon la section 8.1.2 de l'instruction de travail N° TEC-77.		
Quantité: <u>1 KIT</u> Date: <u>27-11-07</u> Sceau:   		
17.0	SÉCHAGE	SÉCHAGE DU MATÉRIEL
		
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs SÉCHAGE DU MATÉRIEL		
Faire le séchage du Rohacell selon les informations du manufacturier		
Inscrire le N° de cuisson: <u>5742</u>		
Quantité: <u>1</u> Date: <u>27-11-07</u> Sceau:   		
18.0	AAC0560	FILM ADHESIF PF-7035-C
Commentair Qty.: 55 UNITE(s)/Unit Total : 55 UNITE(s) FILM ADHESIF PF-7035-C		
N° de Lot: <u>1-6282-1</u>		
19.0	ACP0003	Core splice adhesive MA560.048
Commentair Qty.: 5 UNITE(s)/Unit Total : 5 UNITE(s) Core splice adhesive MA560.048		
N° de Lot: <u>2-6292-1</u>		
20.0	AAC0563	EPOCAST 87269-A/B
Commentair Qty.: 0.25 KIT(s)/Unit Total : 0.25 KIT(s) <u>EPOCAST 87269-A/B ADTECH P-17</u>		
N° de Lot: <u>6420</u>		

Date: Lundi, 2007-11-12 10:54:09

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération:

Description :

21.0 AAC0645 DOUBLER KIT D3140-6-8

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

DOUBLER KIT D3140-6-8 1-6408-2, 1-6309-8, 1-6313-2, 1-6421-1

N° de Lot: 1-6326-2, 1-6408-5, 1-6408-4, 1-6309-2

22.0 NETTOYAGE 3 NETTOYAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

NETTOYAGE GÉNÉRALE

Faire le nettoyage des doublers selon l'instruction générale N° I.G. # Lavage pièce aluminium traité alodine.

Quantité: 1 Kit Date: 28-11-07 Sceau:

Quantité: Date: Sceau:

23.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

ASSEMBLAGE GÉNÉRALE DES PIECES

Mise en place des doublers et des pièces de mousse structurales selon la section 8.1.3 de l'instruction de travail N° TEC-77.

Quantité: / Date: 28-11-07 Sceau:



24.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

Tissu à délaminer Release ply B

25.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

Wrightlon 5200 Bleu P3

26.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

Feutre de drainage N° Airweave N 10

27.0 AC0755 Sac à vide N° Strehlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total : 7.770 METRE CAR(s)

Sac à vide N° Strehlon 700

28.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total : 2.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

te: Lundi, 2007-11-12 10:54:09

lisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

29.0

POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.2 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 28/11/07 Sceau:



30.0 CUISSON 1 CUISSON PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

CUISSON DES PIECES

Faire la cuisson des pièces selon la section 8.3.2 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 28/11/07 Sceau:



31.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

DÉMOULAGE DES PIECES

Retirez le montage cuisson de sur la pièce, et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium, Garder seulement la barre qui sépare les deux pièces.

Quantité: 1

Date: 29-11-07 Sceau:



32.0 DÉCOUPE CORE DÉCOUPE DU CORE DART



Commentair Setup: 0.00Hrs/ Run: 210.0000Min Total Run : 3.5000Hrs

USINAGE DES MOUSSE

Usinage des mousses sturcturales selon la section 8.1.4 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 29-11-07 Sceau:



33.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

INSPECTION GÉNÉRALE

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.

ate: . Lundi, 2007-11-12 10:54:09

tilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42212

Nom Dessin: DOOR  
Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération:

Description :

Quantité: / Date: 30-11-07 Sceau: 

34.0 AMB0211 PREPERG FIBERCOTE E761/7781 roul. 50"

Commentair Qty.: 12.3 VERGE(s)/Unit Total : 12.3 VERGE(s)  
PREPERG FIBERCOTE E761/7781 roul. 50"

N° de Lot: 1-1293-1

35.0 DRAPAGE 1 DRAPAGE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

DRAPAGE DES PIECES

Drapage de la coquille intérieur selon la section 8.1.5 de l'instruction de travail N° TEC-77

Quantité: 3-12-07 Date: / Sceau:   

36.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)  
Tissu à délaminer Release ply B

37.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)  
Wrightlon 5200 Bleu P3

38.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)  
Feutre de drainage N° Airweave N 10

39.0 AC0755 Sac à vide N° Strehlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total : 7.770 METRE CAR(s)  
Sac à vide N° Strehlon 700

40.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total : 2.0000 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

41.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.3 de l'instruction de travail N° TEC-77.

Quantité: / Date: 3-12-07 Sceau:   

Date: Lundi, 2007-11-12 10:54:09

Opérateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42212

Nom Dessin: DOOR  
Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
42.0	CUISSON 1	CUISSON PIÈCE DART
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs CUISSON DES PIECES		
Faire la cuisson de la pièce selon la section 8.3.3 de l'instruction de travail N° TEC-77.		
	Quantité: 1 Date: 3-12-07 Sceau: 16	DELASTEK COMPOSITE 16
		DELASTEK COMPOSITE 34
43.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs DÉMOULAGE DES PIECES		
Retirez le montage cuisson, et faire de retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer.		
Retirer la pièce du moule.		
	Quantité: 1 Date: 10-12-07 Sceau: 23	DELASTEK COMPOSITE 23
44.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs TRIMAGE DE FINITION		
Faire le trimage de finition de la pièce selon la section 8.5 de l'instruction de travail N° TEC-77.		
	Quantité: 1 Date: 13-12-07 Sceau: 23	DELASTEK COMPOSITE 23
45.0	AAC0671	Dupont Primer N° 1104S 7704 CASAEX 9.S. 12-01-08
Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s) Dupont Primer N° 1104S N° de Lot: 1-6254-2 QA-11		
46.0	AAC0670	Dupont Activator N° 7975S 7775S
Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s) Dupont Activator N° 7975S N° de Lot: 1-6473-1		
47.0	AAC0672	Dupont Reducer N° 12375S
Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s) Dupont Reducer N° 12375S N° de Lot: N/A		

Le: Lundi, 2007-11-12 10:54:09  
Auteur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42212

Nom Dessin: DOOR  
Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
48.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs PRÉPARATION DU MATÉRIEL		
Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.		
49.0	INSPECTION 3	INSPECTION PIÈCE DART
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs INSPECTION PIÈCE DART		
Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel "		
Date: 16-01-08 Sceau: QA-11 Initials: H.S.		
50.0	PEINT/ PRIMER2	PEINTURE / PRIMER DART
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs APPLICATION DE PRIMER		
Appliquer une épaisse couche de primer partout sur les deux portes.		
Quantité: 1 Date: 16-01-08 Sceau: 61 D 3140-06 MA		
51.0	PEINT/ PRIMER2	PEINTURE / PRIMER DART
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs APPLICATION DE PRIMER		
Appliquer une épaisse couche de primer partout sur les deux portes.		
Quantité: 1 Date: 24/01/08 Sceau: 65 D 3140-08		
52.0	FINITION 3	FINITION PIÈCE DART
Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs FINITION GÉNÉRALE		
Faire un sablage léger ( Grit 320-400 ) de toute les surfaces.		
Quantité: 1 Date: 25-01-08 Sceau: 61 D 3140-08		

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération:

Description :

53.0 AAC0671

Dupont Primer N° 1104S

7704

7.5. 18-01-08



Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: /-6254-2

54.0 AAC0670

Dupont Activator N° 7975S

7715

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)

Dupont Activator N° 7975S N° de Lot: /-6473-1

55.0 AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)

Dupont Reducer N° 12375S N° de Lot: /N/A

56.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

PRÉPARATION DU MATÉRIEL

JAN 25 2008

Nettoyage tuy 1

JAN 25 2008



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

18-01-07



57.0 PEINT/PRIMER2

PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

APPLICATION DE PRIMER

JAN 25 2008



Application d'une couche de primer de finition partout sur les deux portes.

Quantité: /

Date: 18-01-07

Sceau

D3140-06



58.0 IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

IDENTIFICATION DES PIÈCES

Identifier le numéro de la pièce, le numéro de job ainsi que la date de fabrication sur l'aluminium peinturé dans le dégagement des mécanisme de porte.

Grosse porte : D3140-06



Petite Porte: D3140-08

18-01-08



Quantité: /

Date: 18-01-08

Sceau:

te:  
lisateur Lundi, 2007-11-12 10:54:09  
Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42212

Nom Dessin: DOOR  
Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
59.0	INSPECTION 3	INSPECTION PIÈCE DART
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
INSPECTION GÉNÉRALE		
Inspection finale par le département de la qualité selon le dessin D3140.		
Date: <u>28-01-08</u> Sceau:		Initiales: <u>J.S.</u>
60.0	EMBALLAGE 3	EMBALLAGE PIÈCE DART
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
EMBALLAGE ET ENTREPOSAGE		
Faire l'emballage selon la section 8.7 de l'instruction de travail N° TEC-77		
Quantité: <u>9 Pièces</u> Date: <u>28-01-08</u> Sceau:		<u>11</u>